

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007096**Date Inspected:** 10-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 6/10/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in the Fabrication shop #4 and Foundry at Japan Steel Works (JSW), Muroran, Hokkaido, Japan.

**WEST DEVIATION SADDLES**

W2W1 \* QA Inspector observed JSW personnel in process of removing lifting lugs. No welding is scheduled during period of observance.

W2W2 \* Buttering (surfacing cast material) of lifting lug locations, each end of saddle casting, have been completed in Fabrication Shop #4. The built up plate portion has had areas identified by NIS Technician R. Kumagai, further ground to provide a suitable profile in cope areas for the magnetic particle test to be performed by JSW's QC inspection Technician.

W2W3 \* Saddle Casting is idle in Foundry. CWI QC Inspector Mr. Chung Fu Kuan randomly verified parameters described in procedure SJ-3011-2 as welders M.Inoue 92-5683, T.Watanabe 08-5169 and T.Isobe 08-5176 welded joints W3Y-13L, W3Y-14L and W3Y-17L-2 respectively, with FCAW process and TM95 consumable weld wire.

**TOWER SADDLES**

T1-2 \* QA Inspector noted Tower saddle structure had now been welded to its base plate, currently, only grinding of weld reinforcement is taking place.

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T1-3 \* Nikko Inspection Service will continue testing saddle upon completion of the staging to allow safe access to full length of welds. Currently only staging activity surrounds Saddle T1-3.

### EAST DEVIATION SADDLES

E2E1 \* Saddle casting is undergoing defect grinding to excavations to side opposite the ID in the Foundry shop. This is being performed following the PT and MT of the excavations. In Fabrication Shop #4, Splay plate cover, pc mk 21-1 base to 21-4 was being welded by K.Kobayashi 08-5023 per procedure SJ-3177-2, FCAW, TM55 wire, in a 1G position. This CJP joint is one with backing bar and a 10mm root opening.

E2W1 \* Welders, S.Morohashi 91-2255 and H.Onodera 93-2272 are repairing excavations per repair procedure. Parameters of procedure SJ-3026-4 are being randomly monitored by Weld Engineer Mr. T.Imai in Foundry. In Fabrication Shop #4, MC Shapes (C Channel) are being tacked in by Mr. Y.Ohta 08-2017 using E7016 4mm electrode and procedure SJ-3177-4. Piece Marks identified as 21-1 (bearing plate), and 21-2, 21-3-1, and 21-3-2 (channel).

West Jacking Saddle has one JSW personnel actively shaping by way of Carbon Arc, in Foundry, approximately 47% complete this side.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

#### Summary of Conversations:

No significant conversations to report on this day.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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